

Date: Friday, 11/04/2008 9:02:26 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: FWD X-TUBE		
Job Number	: 38561			Part Number	: D2889		
Estimate Number	: 10006			Drawing Number	: D2889 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 11/04/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: LANDING GEAR	Due Date	: 30/05/2008 Qty: 1 Um: Each		
Previous Run	: 38560						
Written By	:						
Checked & Approved By	: <u>JKO 08-4-11</u>						
Comment	: Est Rev:A New Issue 05-10-25 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6005180	Crosstube material	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Crosstube material Pick: <i>✓ 08-4-24</i>	
		Qty Part number Description Batch <i>✓ 08-4-24</i> 1-D2889 Fwd Crosstube <u>B34687</u>	<i>EL 8-4-24</i>
2.0	BENDING	BENDING MACHINE - SKIDTUBES	
		Comment: LANDING GEAR RESOURCE 1 1-Bend D2889 as per Dwg D2889 and Folio FT001	<i>EL 8-4-24</i>
3.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1 1-Deburr and Polish	<i>✓ 08-4-24</i>
4.0	QC15	DIMENSIONAL CHECK OF X-TUBES	
		Comment: DIMENSIONAL CHECK OF X-TUBES	<i>✓ 08-4-24</i>
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Acid etch and alodine as per QSI 005 4.1 Inside and outside of tube	<i>wat ✓ 08-4-24</i>
			<i>wat ✓ 08-4-24</i>
			<i>wat on wlot# 38631</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/04/2008 9:02:26 AM  
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Drawing Name: FWD X-TUBE

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Used on w/o 38681

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

8.0 QC21 FINAL INSPECTION/W/O RELEASE



08/04/28 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



CMF 08-04-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

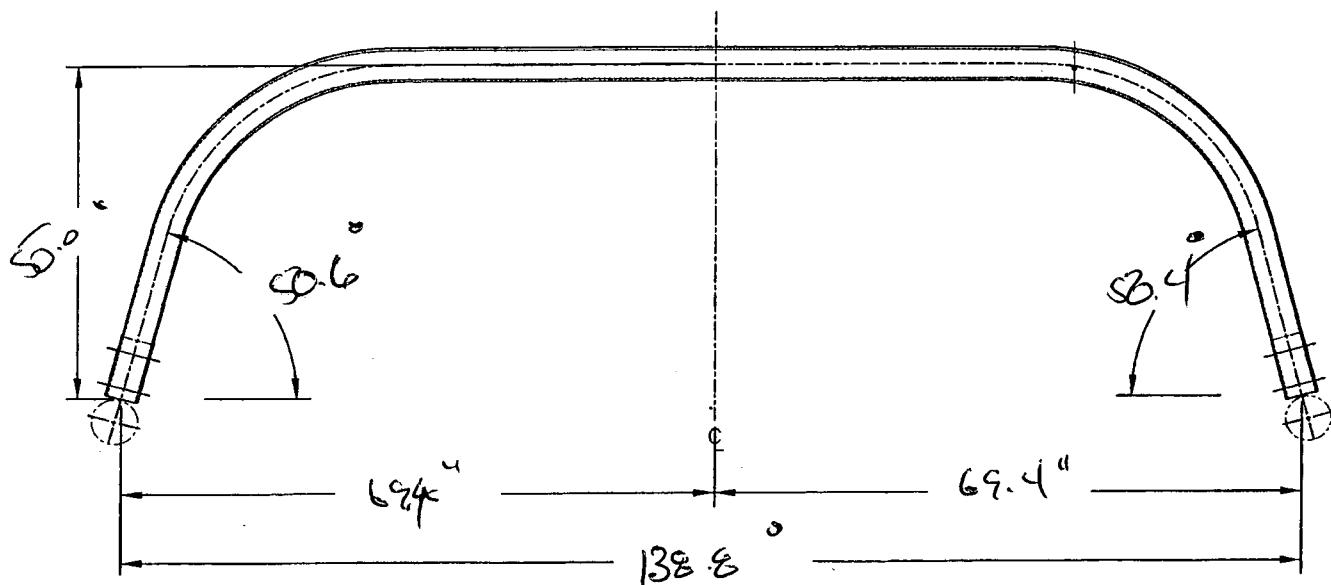
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	385le
Description: Crosstube Fwd	Part Number:	D2889
Inspection Dwg: D2889	Rev: B	Page 1 of 1

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments	
* used on w/0 #38631	

QC15 Inspection	
Date	08/04/24

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	JM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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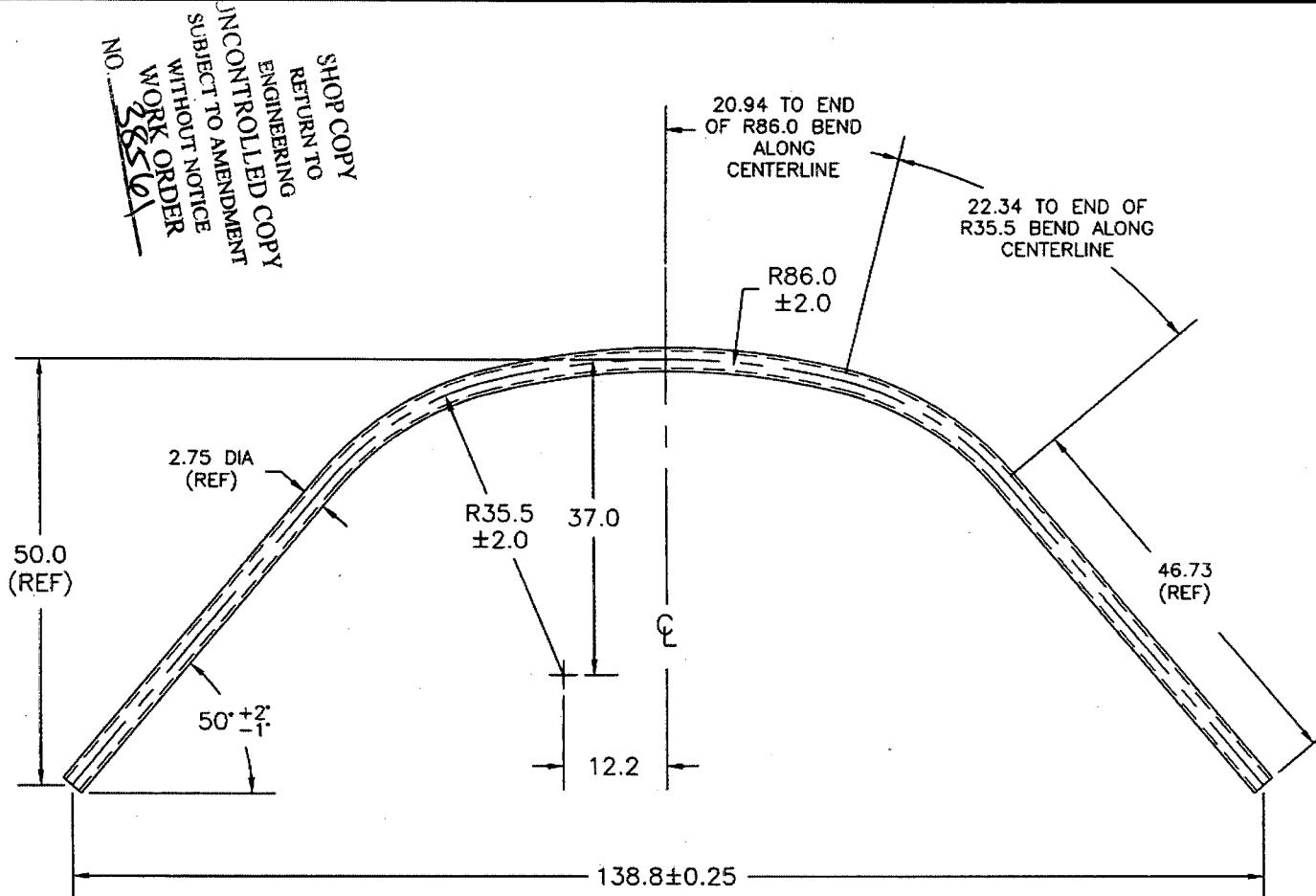
NOTE: Date & initial all entries

**DART**

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA  
REV. B  
DRAWING NO. D2889  
SHEET 1 OF 1  
SCALE 1:20

**RELEASED**  
 02.10.28

DESIGN	DRAWN BY	
<i>H</i>	<i>GP</i>	
CHECKED	APPROVED	
<i>H</i>	<i>GP</i>	
DATE	TITLE	
02.10.18	99.05.21	NEW ISSUE
	02.10.18	FWD CROSSTUBE
		ADD TANGENT LENGTHS; CHANGE NOTES


**NOTES**

- 1) MATERIAL: MANUFACTURE FROM D6005-180 ( $\phi 2.75$  OD x 0.375 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

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